

Date: Monday, 16/10/2006 7:47:54 AM
 User: Linda Laelie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HINGE BRACKET, GAS SPRING		
Job Number	: 28949					
Estimate Number	: 10179					
P.O. Number	: N/A		Part Number	: D2144		
This Issue	: 16/10/2006 S.O. No. : N/A		Drawing Number	: D2144 REV. D		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: 16/10/2006 Type : SMALL /MED FAB		Drawing Revision	: D		
Previous Run	: 28976		Material	: N/A		
Written By			Due Date	: 19/10/2006 Qty: 40 Um: Each		
Checked & Approved By						
Comment						

Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
		
Comment: Qty.: 0.0945 sf(s)/Unit Total : 3.7800 sf(s) 304/316 .063 Sheet 16GA Batch: M101463 <i>M 06/10/17</i>		
2.0	WATER JET	FLOW WATER JET
		
Comment: FLOW WATER JET 1-Cut as per Dwg D2144 Dwg Rev: <i>D</i> <i>M</i> <i>06/10/17</i> <i>42</i> Prog Rev: <i>D</i>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
<i>M 06/10/17</i> <i>42</i>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
		
<i>Job 10.20 42 counter</i>		
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary <i>mF. 06/10/24 42</i>		

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Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2144 Rev: D

SB 06/10/24

(42)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Jas. 0.24 (42)



Comment: INSPECT WORK TO CURRENT STEP

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FAB RESOURCE 1

- 1- Weld corner as per Dwg D2144 & QSI 004
- 2- Grind flush

D

06-10-24

(42)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AA 06/10/25 42

10.0 QC5 INSPECT WORK TO CURRENT STEP



Jas. 0. 25



Comment: INSPECT WORK TO CURRENT STEP

11.0 POWDER COATING POWDER COATING



M101575



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

an 41 06/10/26 X 42

12.0 QC3 INSPECT POWDER COAT/ CHEMICAL CONVERSION



13.0 06/10/26 (42)

Comment: INSPECT POWDER COAT

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST218

PB 06/10/26 (42)

C 06/10/27

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Seq. #: Machine Or Operation:

Description :

14.0 QC21

FINAL INSPECTION/W/O RELEASE



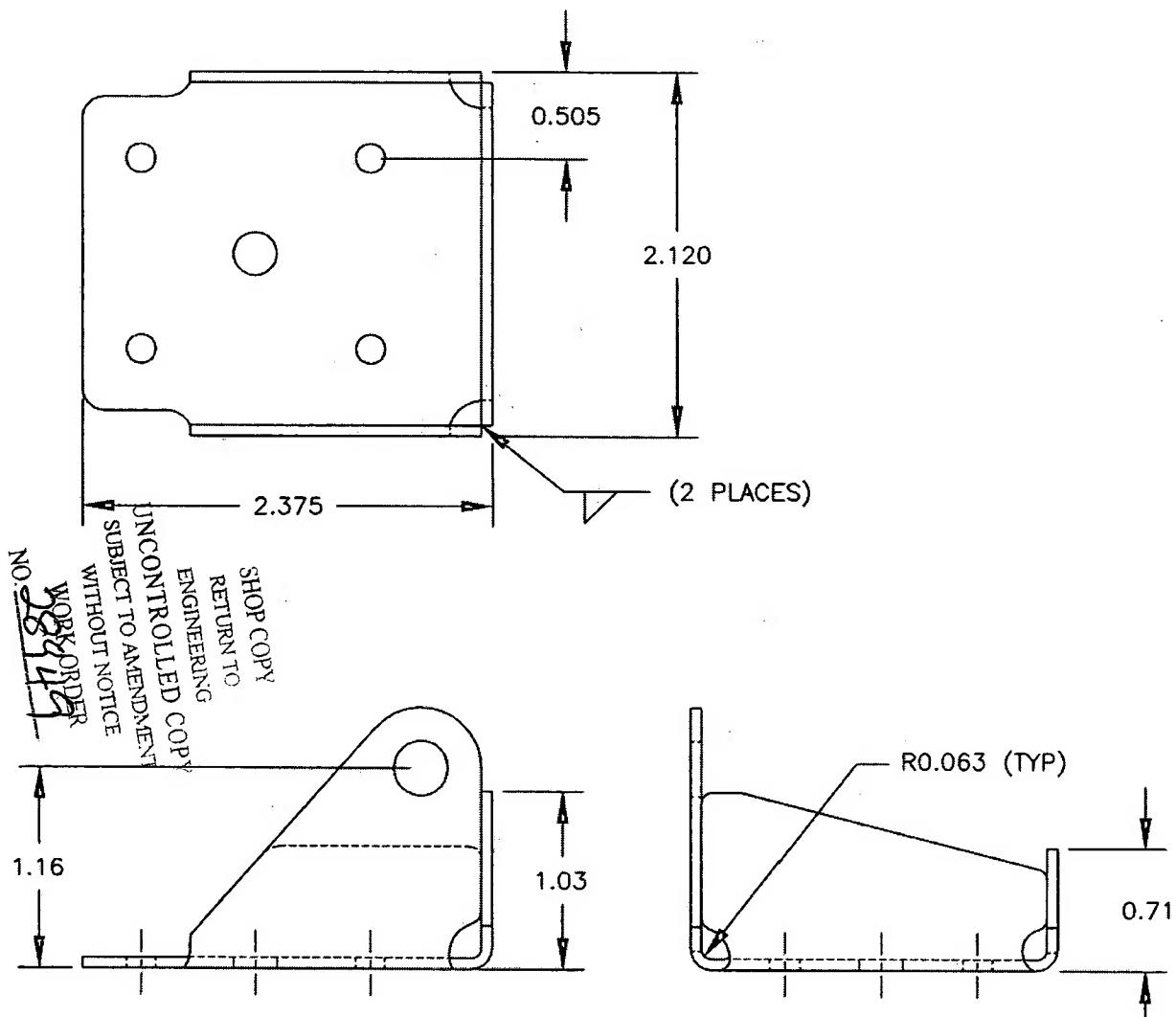
(42)

Comment: FINAL INSPECTION/W/O RELEASE

206/10/27

Job Completion





FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004.

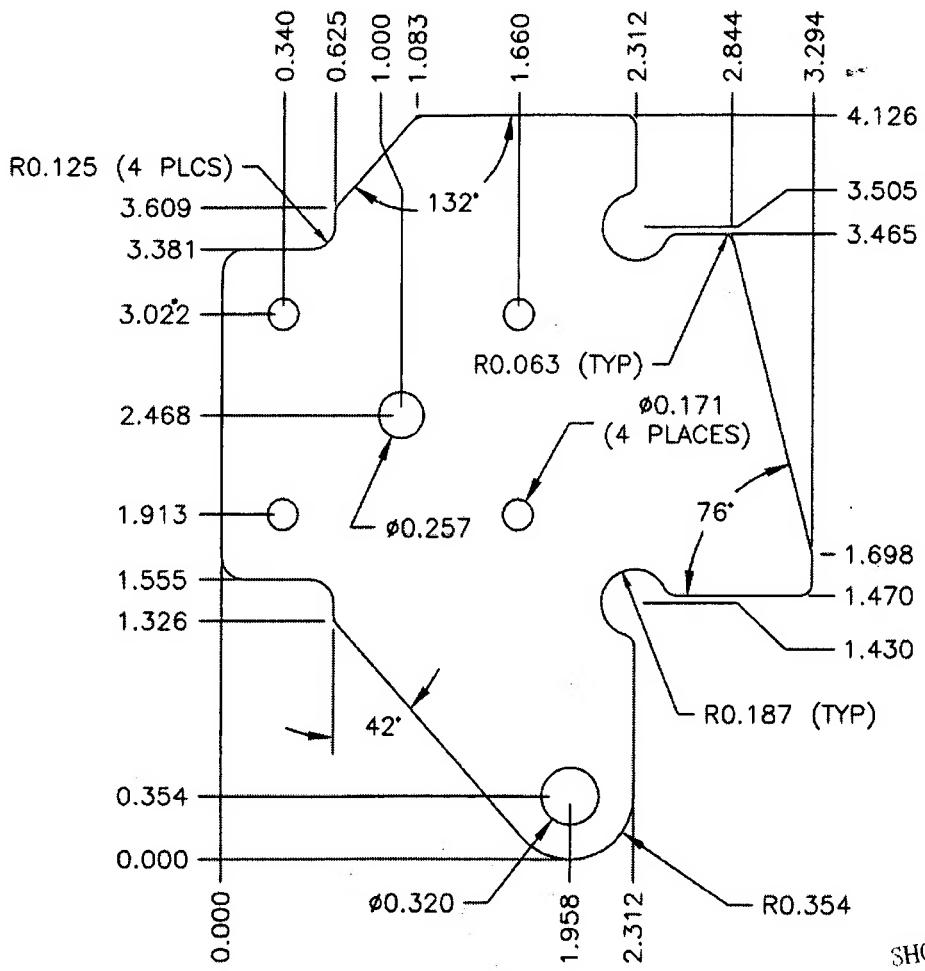
RELEASED
18.10.15 *KE*

DESIGN BY		DART AEROSPACE LTD	REV. D
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.		SHEET 1 OF 2
98.10.08	D2144		
A	95.03.17	NEW ISSUE	
C	96.06.05	FLAT PATTERN LAYOUT ADDED	
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)	1:1



COPY ISSUED
TO

DESIGN <i>BW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2144
DATE 98.10.08	TITLE HINGE BRACKET	REV. D SHEET 2 OF 2 SCALE 1:1

RELEASED
98.10.15 KB

D2144 FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *28949*

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD	Work Order:	28949
Description: Hinge bracket GAS SPRING	Part Number:	D2144
Inspection Dwg: 2144 Rev: 1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>M.M.</u>	Audited by:	<u>/</u>	Prototype Approval:	
Date:	06/10/17	Date:	06-10-20	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	